

Monday, 4/23/2007 3:41:34 PM
Kim Johnston

Process Sheet

Split
SD 07/12/19

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 32016 *B*
Estimate Number : 10267
P.O. Number : *N/A*
This Issue : 4/23/2007 S.O. No. : *N/A*
Print Rev. : *NC*
First Issue : *N/A* Type : PURCHASED PARTS
Previous Rev : 30631
Entered By : *07.04.23*
Checked & Approved By : *07.04.23*
Comment : Est: E 05 06.28 Bending removed KJ/JLM

Drawing Name : CLAMP
Part Number : D2438
Drawing Number : D2438 REV. C
Project Number : *N/A*
Drawing Revision : C
Material : *N/A*
Due Date : 6/15/2007

Qty: 200 Ums: Each

Additional Product:

Number:



Seq. #:

Machine Or Operation:

Description:

10

FE

PURCHASING



Comment: PURCHASING

Issue P/O: *3619*

Laser cut as per Dwg D2438

Material release note is required

07/04/24 200

656 laser cut + formed

20

D2438B

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 200.0000 Each(s)

CLAMP

30

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

7/12/14 SD 200

40

DIF6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(5.786" center to center)

07.12.19

100

50

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges

MF 07-12-19

120 1

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 32016

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

CC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/12/19 (1)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12 7/12/19 (1)

8.0

CC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07/12/19 (1)

Job Completion

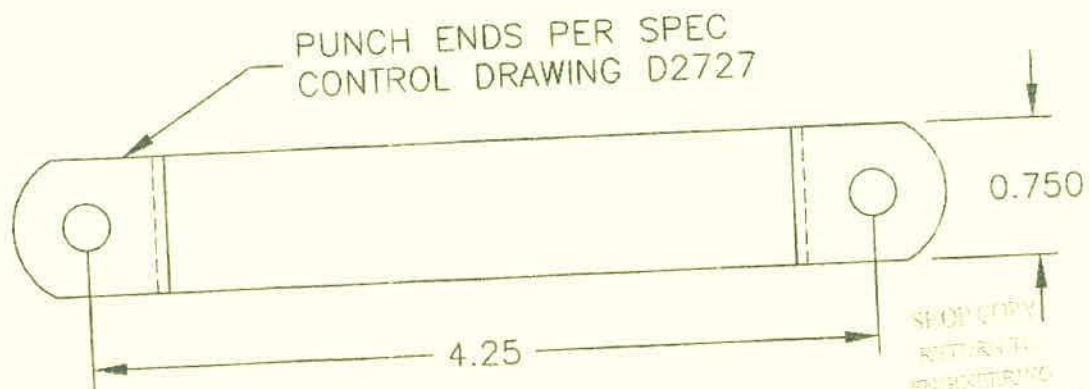
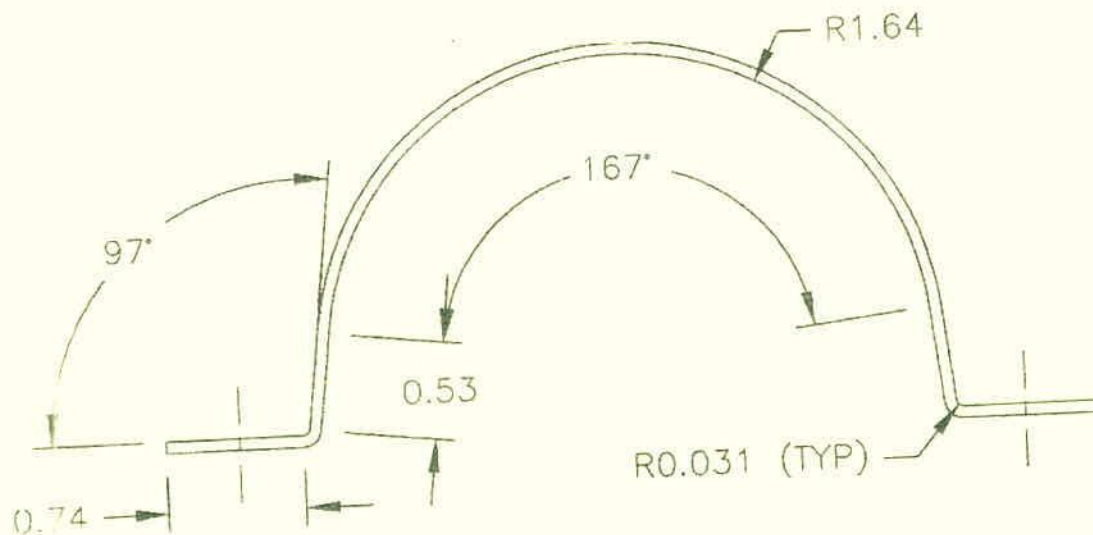


u 07/12/19



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>BD</i>	APPROVED <i>CS</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12	TITLE CLAMP		SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED
99.06.17 KE



FLAT LENGTH: 7.586 END-END
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK
MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32016

00 06 06
CP 00 06 07

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Thomas Betts

18 LAFAYETTE AVENUE
POINTE CLAIRE, QC

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

REF ID NO.	12	OUR JOB NO.	J0172854	SHIPPING MEMO	0381158
INSTR.	PURCHASE ORDER	PART NUMBER	REV.	NAME	DWG. ISSUE
PCS	PO00003619	D2438B	C	CLAMP	C
MATERIAL	SUPPLIED BY			MAT. REL. NO.	
A.S.T 304	TW METALS / NORTH AMERICAN			1X16	

PROCESS	PROCESSOR	RELEASE NOTE
TEST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS

WE CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED BY THE SUPPLIER SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE REQUIREMENTS AND PURCHASE ORDER REFERENCED ABOVE.

DATE: 13 DECEMBER 2007

G.F.I. Q.C. REP. *David St. John*

10/11/2007 15:27 #655 P.003/003

From: FERGUSON METALS

FERGUSON METALS, INC.
This is to certify that in accordance with the
records in our files the material shipped on your
purchase order conforms to the following:
3475 SYNNEX ROAD
HAMILTON, OH 45015

QTY: 51
P.O.: 49175261
Sales: 01094158
QTY: 51

Site: JUAL 22N, 06D, 084 AMS 5513/5511
Customer: TW METALS INC.
Plant: LXL6
Shipped: 05/13/07

Authorized Signature
Lynda Hargreaves

Lynda Hargreaves



NORTH AMERICAN
STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East
Ghent, KY 41045-9615
(502) 347-6000

Certificate: 357787 02

Mail To:
FERGUSON METALS INC.
3475 SYNNEX ROAD
HAMILTON, OH 45015

Ship To:
FERGUSON METALS INC.
3475 SYNNEX ROAD
HAMILTON, OH 45015

Customer: 0018 001

Date: 5/02/2007 Page: 1

Steel: 104/304L

Finish: 2B

Your Order: 01009705

NAS Order: AN 0366117 02

Corrosion: ASTM A262/02MB; 1803and-GK

PRODUCT DESCRIPTION

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.
ASTM A240/06b, 480/06b, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04
Q35766D-A XMCPRM, AMS 5511H/5513H XNRR&FN, MIL 4043B, AMS 3, XCRN28A3&FN

REMARKS:

Mat'l free of Hg content. No weld repairs. RoHS-Compliant.
EN 10204 3.1 PED 97/23/EC Annex 1, Para. 4.3 Q35763F Cond A
* Melted & Manufactured in the USA

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces	COMMODITY CODE
021XL6 A	021XL6 A	.0520	48.0000	10,350 COIL	992.80	11	1	

CHEMICAL ANALYSIS

CA(Country of Melt) ES(Spain) US(United States) ZA(South Africa)

Heat	CM	C	CR	CU	MN	MO	S	NI	P	S	SI
1XL6	08	.022	18.935	.396	1.815	.323	.096	9.615	.030	.010	.160

MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i o r	UTS KSI	.2% YS KSI	ZLONG % -2"	HARD RB	Tail Hard
021XL6 A	021XL6	F T	91.80	45.40	46.22	82.00	93.50

REVIEWED BY Q.C.
Date 5/4/07 by L

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

5/02/2007

